

### **REMARKS/ARGUMENTS**

Claims 1-6 and 8-17 are now pending. Claims 1-17 were rejected as unpatentable over Forte in view of Antoon, Jr.

Applicant appreciates the thorough examination reflected in the Office Actions issued thus far. However, Applicant respectfully traverses the rejections for the following reasons.

#### **A. The Combined References Still Fail to Teach the Claimed Invention**

In the Office Action of September 22, 2005, the silicone-coated microporous film of Antoon, Jr. is deemed to correspond to the claimed intermediate microporous layer, and it is asserted that a person of ordinary skill in the art would have been motivated to use Antoon, Jr.'s microporous film as the "B" layer of Forte's breathable film, "since silicone-coated microporous film is well known to be a water vapor permeable microporous film as taught by Antoon, Jr." The outer "C" layers of Forte's film are asserted to meet the outer layers formed from heat sealable composition as claimed. This basis of rejection is repeated in the final Office Action.

As noted in Section B below, Applicant submits that Forte and Antoon, Jr. would not have been combined as asserted in the Office Action. However, even if Forte and Antoon, Jr. were combined, they still would not teach the invention as claimed. In particular, the combination would not have the outer layers formed from heat sealable composition as claimed. Each of the independent claims has been amended to include the limitations of Claim 7 reciting that the heat-sealable composition of the outer layers comprises at least one of polyolefin, ethylene vinyl acetate, ethylene methyl acrylate, ethylene butyl acrylate, ethylene methyl acid and ionomer as a primary polymer. Since this limitation was already present in the claims, these amendments do not raise any new issue or require any new search, and hence the amendments should be entered and considered.

Forte does not teach or suggest outer layers formed of such heat-sealable polymers.

Forte teaches that the outer “monolithic” layers C of his film must be a *hydrophilic* polymeric resin (col. 6, lines 45-47). Specific examples of such resins are cited as *polyesters*, *polyamides*, and grades of *polyvinyl alcohol* and *ethyl vinyl alcohol* (col. 6, lines 55-59). Also cited are commercial products such as Pebax®, Hytrel®, and Eastman resins (col. 6, lines 60-67). The Pebax® resins are polyether block amides (PEBA)—see the MatWeb web site printouts enclosed herewith. It will be noted that the Pebax® resins generally have a relatively high water absorption (ASTM D570) of 1.2%, which is consistent with Forte’s description of these resins as hydrophilic.

The Hytrel® resins are polyester elastomers—see the MatWeb printouts enclosed herewith. Water absorption data is given only for the G4778 grade, and is listed as 2.3%, which again is consistent with Forte’s description of the Hytrel® resins as hydrophilic.

Although detailed information on the Eastman 14776 resin could not be obtained, this material is believed to be a copolyester (see U.S. Patent No. 6,730,057 at col. 12, lines 26-31).

Thus, the materials cited by Forte for his outer “C” layers are entirely different from the claimed polymers in the amended claims. Significantly, Forte’s “C” layers are not used as “heat-sealable” layers, as persons of ordinary skill in the art would understand. The purpose of the “C” layers is to absorb moisture. Those skilled in the art would not choose PVA, EVOH, polyamide, or polyester as outer heat-sealable layers in a multilayer film, because these materials have relatively high melting temperatures. Outer heat-sealable layers in a multilayer film are generally desired to have low melting temperatures so that the heat-sealable layers can be melted without risk of melting the other layers of the film.

It should also be noted that the claimed materials for the outer heat-sealable layers in the present claims are not particularly hydrophilic. The Modern Plastics Encyclopedia (McGraw-Hill, 1992) gives the following data for water absorption and melting temperatures of various polymers (the page number being cited for each polymer):

Polymer	Melting Temperature, °C	Water Absorption, %
EVOH (p. 385)	142-191	6.7-8.6
polyamide (p. 391)	210-220	1.3-1.9
PET (p. 403)	245-265	0.1-0.2
ionomer (p. 387)	81-96	0.1-0.5
polyethylene (LDPE) (p. 408-409)	98-115	<0.01
EVA (p. 408-409)	103-108	0.005-0.13
EMA (p. 408-409)	83	0
HDPE (p. 408-409)	130-137	<0.01
polypropylene (p. 415)	160-175	0.01-0.03

Forte's hydrophilic polymers such as EVOH, polyester, and polyamide have high melting temperatures in comparison with true "heat-sealable" materials such as polyolefins (e.g., polyethylene), EVA, EMA, and ionomer, as recited in the present claims.

Thus, Forte's disclosure actually teaches away from a multilayer film as claimed, having heat-sealable outer layers comprising at least one of polyolefin, ethylene vinyl acetate, ethylene methyl acrylate, ethylene butyl acrylate, ethylene methyl acid and ionomer as a primary polymer. **Because these claimed polymers are not hydrophilic, Forte's disclosure teaches away from their use in Forte's film.**

Furthermore, with respect to Claim 10, the combination of Forte and Antoon, Jr., even if made, fails to disclose or suggest a multilayer film having first and second outer layers and a center layer each independently comprising a heat sealable composition comprising at least one

Appl. No.: 10/661,848  
Amdt. dated 04/12/2006  
Reply to Office action of January 24, 2006

of polyolefin, ethylene vinyl acetate, ethylene methyl acrylate, ethylene butyl acrylate, ethylene methyl acid and ionomer as a primary polymer.

For at least the above reasons, it is respectfully submitted that the rejections of Claims 1-17 are erroneous and should be withdrawn.

#### B. Forte and Antoon, Jr. Would Not Have Been Combined

Forte specifically describes that the breathability he seeks for his film requires the ability to pass water vapor and oxygen at moderate to high transmission rates (col. 1, lines 16-20). A person of ordinary skill in the art considering Antoon, Jr.'s disclosure would have understood that the silicone-coated microporous film described as "substantially oxygen-impermeable" would be a poor choice for use in Forte's multilayer film where such breathability is a key objective (col. 3, lines 12-13). Antoon, Jr.'s silicone-coated microporous film does not fit this requirement because it is substantially oxygen-impermeable.

Therefore, there would not have been any motivation to use Antoon, Jr.'s silicone-coated microporous film as the "B" layer of Forte's multilayer breathable film, and indeed there would have been a strong disincentive to use it. Accordingly, the combination of Forte and Antoon, Jr. would not have been made.

For at least this additional reason, Applicant submits that the rejections of Claims 1-17 are erroneous and should be withdrawn.

#### Conclusion

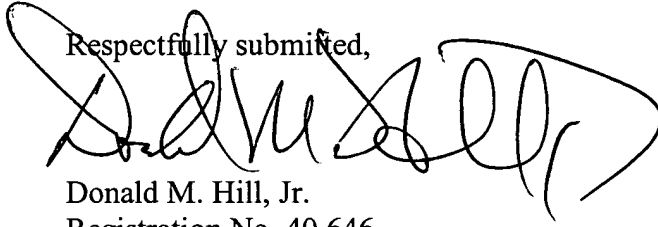
Based on the above amendments and remarks, it is submitted that the rejections have been overcome and the application is in condition for allowance.

It is not believed that extensions of time or fees for net addition of claims are required, beyond those that may otherwise be provided for in documents accompanying this paper.

Appl. No.: 10/661,848  
Amdt. dated 04/12/2006  
Reply to Office action of January 24, 2006

However, in the event that additional extensions of time are necessary to allow consideration of this paper, such extensions are hereby petitioned under 37 CFR § 1.136(a), and any fee required therefor (including fees for net addition of claims) is hereby authorized to be charged to Deposit Account No. 16-0605.

Respectfully submitted,

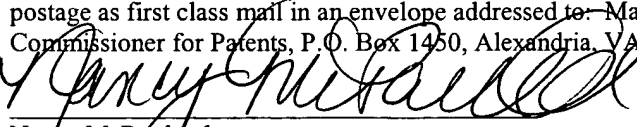


Donald M. Hill, Jr.  
Registration No. 40,646

**Customer No. 00826**  
**ALSTON & BIRD LLP**  
Bank of America Plaza  
101 South Tryon Street, Suite 4000  
Charlotte, NC 28280-4000  
Tel Charlotte Office (704) 444-1000  
Fax Charlotte Office (704) 444-1111

CERTIFICATE OF MAILING

I hereby certify that this correspondence is being deposited with the United States Postal Service with sufficient postage as first class mail in an envelope addressed to: Mail Stop Amendment, Commissioner for Patents, P.O. Box 1450, Alexandria, VA 22313-1450, on April 12, 2006



Nancy McPartland

CLT01/4797404v1



Data sheets for over 55,000 metals, plastics, ceramics, and composites.

MATERIAL PROPERTY DATA

Searches: Advanced | Material Type | Property | Composition | Trade Name | Manufacturer

Advertise with MatWeb!

REGISTER NOW

HOME • SEARCH • TOOLS • SUPPLIERS • FOLDERS • ABOUT US • FAQ • LOGIN

SEARCH



## Arkema Group Pebax® MX 1205 Polyether Block Amide (PEBA)



Printer friendly version



Download to Excel (requires Excel and Windows)



Export data to your CAD/FEA program



Return to last search

Add to Folder: ☐

Subcategory: Elastomer, TPE; Polyether Block Amide (PEBA); Polymer; Thermoplastic

### Material Notes:

Typical application: Impact modifier

Information provided by Arkema Group

### Physical Properties

Density

Metric

English

1.01 g/cc

0.0365 lb/in<sup>3</sup>

Water Absorption

1.2 %

1.2 %

Water Absorption at Saturation

0.4 %

0.4 %

Melt Flow

9 g/10 min

9 g/10 min

Comments

ASTM D792

24 hr in water at 20°C; ASTM D570

20°C and 65% RH; ASTM D570

ASTM D1238

### Mechanical Properties

Hardness, Shore D

42

42

Tensile Strength at Break

36 MPa

5220 psi

ASTM D2240

ASTM D638

BEST AVAILABLE COPY

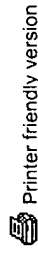
Elongation at Break	600 %	600 %	ASTM D638
Flexural Modulus	<u>0.078 GPa</u>	11.3 ksi	ASTM D790
Izod Impact, Notched	NB	NB	ASTM D256-A
Izod Impact, Unnotched	NB	NB	ASTM D256-A
Izod Impact, Notched @ -40°C	NB	NB	ASTM D256-A
Izod Impact, Unnotched @ -40°C	NB	NB	ASTM D256-A

## Electrical Properties

Surface Resistance	3e+012 ohm	3e+012 ohm	20°C and 65% RH; ASTM D257
--------------------	------------	------------	----------------------------

## Thermal Properties

Heat of Fusion	22 J/g	9.46 BTU/lb	ASTM D3417
CTE, linear 20°C	<u>200 µm/m-°C</u>	111 µin/in-°F	-40°C to 140°C; ASTM D696
Melting Point	<u>147 °C</u>	297 °F	ASTM D3418
Deflection Temperature at 0.46 MPa (66 psi)	<u>52 °C</u>	126 °F	ASTM D648
Vicat Softening Point	<u>114 °C</u>	237 °F	under 1 daN; ASTM D1525



Some of the values displayed above may have been converted from their original units and/or rounded in order to display the information in a consistent format. Users requiring more precise data for scientific or engineering calculations can click on the property value to see the original value as well as raw conversions to equivalent units. We advise that you only use the original value or one of its raw conversions in your calculations to minimize rounding error. We also ask that you refer to MatWeb's disclaimer and terms of use regarding this information. [Click here](#) to view all the property values for this datasheet as they were originally entered into MatWeb.

**CLICK**  
for **FREE**  
Information Technology  
publication subscriptions.

No catch.  
No charge.  
No kidding!  
Subscribe Today!

### Subscribe to Premium Services

**Searches:** Advanced • Composition • Property • Material Type • Manufacturer • Trade Name • UNS Number  
**Other Links:** Advertising • Submit Data • Database Licensing • Web Design & Hosting • Trade Publications  
 Supplier List • Unit Converter • Reference • News • Links • Help • Contact Us • Site Map • FAQ • Home

Please read our License Agreement regarding materials data and our Privacy Policy. Questions or comments about MatWeb? Please contact us at [webmaster@matweb.com](mailto:webmaster@matweb.com). We appreciate your input.

Site designed and maintained by Automation Creations, Inc. The contents of this web site, the MatWeb logo, and "MatWeb" are Copyright 1996-2006 by Automation Creations, Inc. MatWeb is intended for personal, non-commercial use. The contents, results, and technical data from this site may not be reproduced either electronically, photographically or substantively without

permission from Automation Creations, Inc.





Data sheets for over 55,000 metals, plastics, ceramics, and composites.

MATERIAL PROPERTY DATA

[Advertise with MatWeb!](#)
[REGISTER NOW](#)
[HOME](#) • [SEARCH](#) • [TOOLS](#) • [SUPPLIERS](#) • [FOLDERS](#) • [ABOUT US](#) • [FAQ](#) • [LOGIN](#)
[Searches: Advanced](#) | [Material Type](#) | [Property](#) | [Composition](#) | [Trade Name](#) | [Manufacturer](#)
[SEARCH](#)


## Arkema Group Pebax® 4033 Polyether Block Amide (PEBA)


[Printer friendly version](#)

[Download to Excel \(requires Excel and Windows\)](#)

[Export data to your CAD/FEA program](#)

[Return to last search](#)
[Add to Folder:](#) ☐
**Subcategory:** Elastomer, TPE; Polyether Block Amide (PEBA); Polymer; Thermoplastic

### Material Notes:

Typical application: Mechanical parts

Information provided by Arkema Group

### Physical Properties

Density

Metric

English

 1.01 g/cc    0.0365 lb/in<sup>3</sup>

Water Absorption

1.2 %

Water Absorption at Saturation

0.5 %

Melt Flow

5 g/10 min    5 g/10 min

Comments

ASTM D792

24 hr in water at 20°C; ASTM D570

20°C and 65% RH; ASTM D570

ASTM D1238

### Mechanical Properties

Hardness, Shore D

42

ASTM D2240

Tensile Strength at Break

36 MPa    5220 psi

ASTM D638

Elongation at Break	450 %	450 %	ASTM D638
Modulus of Elasticity	<u>0.05 GPa</u>	7.25 ksi	ASTM D638
Flexural Modulus	<u>0.084 GPa</u>	12.2 ksi	ASTM D790
Resilience	0.625	0.625	BS 903 par: A 8
Flex Crack Resistance	2	2	[mm] 20°C / 100000 flexures; ASTM D813
Flex Crack Resistance	4.5	4.5	[mm] -20°C / 50000 flexures; ASTM D813
Izod Impact, Notched	NB	NB	ASTM D256-A
Izod Impact, Unnotched	NB	NB	ASTM D256-A
Tear Strength	<u>70 kN/m</u>	399 pli	notched; ASTM D624 (C)
Tear Strength	<u>95 kN/m</u>	542 pli	unnotched; ASTM D624 (C)
Taber Abrasion, mg/1000 Cycles	70	70	ASTM D1242
Abrasion	80	80	mm <sup>3</sup> ; DIN 53516
Compression Set	21 %	21 %	Load = 9.3 MPa (22 hr / 70°C); ASTM D395 Method A
Izod Impact, Notched @ -40°C	NB	NB	ASTM D256-A
Izod Impact, Unnotched @ -40°C	NB	NB	ASTM D256-A

### Electrical Properties

Surface Resistance	5e+012 ohm	5e+012 ohm	20°C and 65% RH; ASTM D257
--------------------	------------	------------	----------------------------


### Thermal Properties

Heat of Fusion	<u>24 J/g</u>	10.3 BTU/lb	ASTM D3417
CTE, linear 20°C	<u>195 µm/m-°C</u>	108 µin/in-°F	-40°C to 140°C; ASTM D696
Melting Point	<u>160 °C</u>	320 °F	ASTM D3418
Deflection Temperature at 0.46 MPa (66 psi)	<u>52 °C</u>	126 °F	ASTM D648
Vicat Softening Point	<u>132 °C</u>	270 °F	under 1 daN; ASTM D1525


[Printer friendly version](#)

Some of the values displayed above may have been converted from their original units and/or rounded in order to display the information in a consistent format. Users requiring more precise data for scientific or engineering calculations can click on the property value to see the original value as well as raw conversions to equivalent units. We advise that you only use the original value or one of its raw conversions in your calculations to minimize rounding error. We also ask that you refer to MatWeb's disclaimer and terms of use regarding this information. [Click here](#) to view all the property values for this datasheet as they were originally entered into MatWeb.

**CLICK**  
for **FREE**  
Information Technology  
publication subscriptions.



No catch.  
No charge.  
No kidding!  
Subscribe Today!

**Subscribe to Premium Services**

**Searches:** Advanced • Composition • Property • Material Type • Manufacturer • Trade Name • UNS Number  
**Other Links:** Advertising • Submit Data • Database Licensing • Web Design & Hosting • Trade Publications  
Supplier List • Unit Converter • Reference • News • Links • Help • Contact Us • Site Map • FAQ • Home

Please read our License Agreement regarding materials data and our Privacy Policy. Questions or comments about MatWeb? Please contact us at [webmaster@matweb.com](mailto:webmaster@matweb.com). We appreciate your input.

Site designed and maintained by Automation Creations, Inc. The contents of this web site, the MatWeb logo, and "MatWeb" are Copyright 1996-2006 by Automation Creations, Inc. MatWeb is intended for personal, non-commercial use. The contents, results, and technical data from this site may not be reproduced either electronically, photographically or substantively without permission from Automation Creations, Inc.



Data sheets for over 55,000 metals, plastics, ceramics, and composites.

Searches: Advanced | Material Type | Property | Composition | Trade Name | Manufacturer

Advertise with MatWeb!

REGISTER NOW

HOME • SEARCH • TOOLS • SUPPLIERS • FOLDERS • ABOUT US • FAQ • LOGIN

SEARCH



## Arkema Group Pebax® 3533 Polyether Block Amide (PEBA)

Return to last search  
Add to Folder: ☐

- Printer friendly version
- Download to Excel (requires Excel and Windows)
- Export data to your CAD/FEA program

**Subcategory:** Elastomer, TPE; Polyether Block Amide (PEBA); Polymer; Thermoplastic

### Material Notes:

Information provided by Arkema Group

### Physical Properties

	Metric	English	Comments
Density	1.01 g/cc	0.0365 lb/in <sup>3</sup>	ASTM D792
Water Absorption	1.2 %	1.2 %	24 hr in water at 20°C; ASTM D570
Water Absorption at Saturation	0.5 %	0.5 %	20°C and 65% RH; ASTM D570
Melt Flow	8 g/10 min	8 g/10 min	ASTM D1238

### Mechanical Properties

Hardness, Shore A	83	83	ASTM D2240
Hardness, Shore D	33	33	ASTM D2240
Tensile Strength at Break	30 MPa	4350 psi	ASTM D638

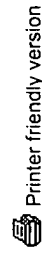
Elongation at Break	<u>670 %</u>	670 %	ASTM D638
Modulus of Elasticity	<u>0.0146 GPa</u>	2.12 ksi	ASTM D638
Flexural Modulus	<u>0.025 GPa</u>	3.63 ksi	ASTM D790
Resilience	0.7	0.7	BS 903 par: A 8
Flex Crack Resistance	2	2	[mm] 20°C / 100000 flexures; ASTM D813
Flex Crack Resistance	2.5	2.5	[mm] -20°C / 50000 flexures; ASTM D813
Izod Impact, Notched	NB	NB	ASTM D256-A
Izod Impact, Unnotched	NB	NB	ASTM D256-A
Tear Strength	<u>45 kN/m</u>	257 pli	notched; ASTM D624 (C)
Tear Strength	<u>71 kN/m</u>	405 pli	unnotched; ASTM D624 (C)
Taber Abrasion, mg/1000 Cycles	81	81	ASTM D1242
Abrasion	96	96	mm <sup>3</sup> ; DIN 53516
Compression Set	<u>54 %</u>	54 %	Load = 9.3 MPa (22 hr / 70°C); ASTM D395 Method A
Izod Impact, Notched @ -40°C	NB	NB	ASTM D256-A
Izod Impact, Unnotched @ -40°C	NB	NB	ASTM D256-A

### Electrical Properties

Surface Resistance	2e+012 ohm	2e+012 ohm	20°C and 65% RH; ASTM D257
--------------------	------------	------------	----------------------------

### Thermal Properties


Heat of Fusion	<u>11 J/g</u>	4.73 BTU/lb	ASTM D3417
CTE, linear 20°C	<u>210 µm/m-°C</u>	117 µin/in-°F	-40°C to 140°C; ASTM D696
Melting Point	<u>143.5 °C</u>	290 °F	ASTM D3418
Deflection Temperature at 0.46 MPa (66 psi)	<u>46 °C</u>	115 °F	ASTM D648
Vicat Softening Point	<u>74 °C</u>	165 °F	under 1 daN; ASTM D1525


[Printer friendly version](#)

Some of the values displayed above may have been converted from their original units and/or rounded in order to display the information in a consistent format. Users requiring more precise data for scientific or engineering calculations can click on the property value to see the original value as well as raw conversions to equivalent units. We advise that you only use the original value or one of its raw conversions in your calculations to minimize rounding error. We also ask that you refer to MatWeb's disclaimer and terms of use regarding this information. [Click here](#) to view all the property values for this datasheet as they were originally entered into MatWeb.

CLICK

for **FREE**  
Information Technology  
publication subscriptions.



No catch.  
No charge.  
No kidding!  
Subscribe Today!

Subscribe to Premium Services

**Searches:** Advanced • Composition • Property • Material Type • Manufacturer • Trade Name • UNS Number  
**Other Links:** Advertising • Submit Data • Database Licensing • Web Design & Hosting • Trade Publications  
Supplier List • Unit Converter • Reference • News • Links • Help • Contact Us • Site Map • FAQ • Home

Please read our License Agreement regarding materials data and our Privacy Policy. Questions or comments about MatWeb? Please contact us at [webmaster@matweb.com](mailto:webmaster@matweb.com). We appreciate your input.

Site designed and maintained by Automation Creations, Inc. The contents of this web site, the MatWeb logo, and "MatWeb" are Copyright 1996-2006 by Automation Creations, Inc. MatWeb is intended for personal, non-commercial use. The contents, results, and technical data from this site may not be reproduced either electronically, photographically or substantively without permission from Automation Creations, Inc.



Data sheets for over 55,000 metals, plastics, ceramics, and composites.

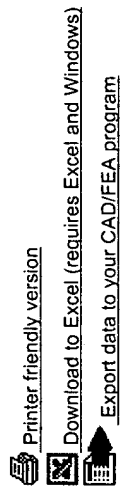
HOME • SEARCH • TOOLS • SUPPLIERS • FOLDERS • ABOUT US • FAQ • LOGIN

[Advertise with MatWeb!](#)
[REGISTER NOW](#)

Searches: Advanced | Material Type | Property | Composition | Trade Name | Manufacturer

[SEARCH](#)


## Arkema Pebax® MV 1041 SN 01 Polyether Block Amide (PEBA) (Dry)


[Return to last search](#)  
 Add to Folder: ☐
**Subcategory:** Elastomer, TPE; Polyether Block Amide (PEBA); Polymer; Thermoplastic

**Close Analogs:**

Arkema, formed in 2004, was formerly Atofina Chemicals and before that Elf Atochem.

**Key Words:** Thermoplastic Elastomer, TPE

**Material Notes:**

 POLYETHER BLOCK AMIDE (PEBA) hardness 60 shore D breathable (high permeability to H<sub>2</sub>O vapor, CO<sub>2</sub>, O<sub>2</sub>) permanent antistatic grade Applications: breathable films (medical, textile....)

ISO data provided by the manufacturer, Arkema.

 No vendors are listed for this material. Please [click here](#) if you are a supplier and would like information on how to add your listing to this material.

**Physical Properties**
**Metric**      **English**

Density

 1.04 g/cc      0.0376 lb/in<sup>3</sup>

Water Absorption

12 %

**Comments**

BEST AVAILABLE COPY

Moisture Absorption at Equilibrium	1 %	Humidity Absorption
Melt Flow	7.3 g/10 min	235°C/1 kg load

### Mechanical Properties

Hardness, Shore D	60	
Tensile Strength, Yield	17 MPa	2470 psi
Elongation at Break	Min 50 %	Min 50 %
Elongation at Yield	26 %	26 %
Tensile Modulus	0.253 GPa	36.7 ksi
Charpy Impact, Unnotched	NB	NB
Charpy Impact, Notched Low Temp	1.14 J/cm <sup>2</sup>	5.43 ft-lb/in <sup>2</sup>
Charpy Impact, Unnotched Low Temp	NB	NB
Charpy Impact, Notched	NB	NB

### Electrical Properties

Electrical Resistivity	5.52e+012 ohm-cm	5.52e+012 ohm-cm
Surface Resistance	5.96e+012 ohm	5.96e+012 ohm
Dielectric Strength	43.5 kV/mm	1100 kV/in
Dissipation Factor	0.00048	0.00048
Dissipation Factor, Low Frequency	0.00127	0.00127

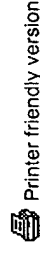
### Thermal Properties

Melting Point	170 °C	338 °F
Oxygen Index	22.9 %	22.9 %

### Optical Properties

Transmission, Visible	80 %	80 %
-----------------------	------	------

Mfr. reports 'Transparent' but doesn't quantify.



[Printer friendly version](#)

Some of the values displayed above may have been converted from their original units and/or rounded in order to display the information in a consistent format. Users requiring more precise data for scientific or engineering calculations can click on the property value to see the original value as well as raw conversions to equivalent units. We advise that you only use the original value or one of its raw



conversions in your calculations to minimize rounding error. We also ask that you refer to MatWeb's disclaimer and terms of use regarding this information. [Click here](#) to view all the property values for this datasheet as they were originally entered into MatWeb.



**Subscribe to Premium Services**

**Searches:** Advanced • Composition • Material Type • Manufacturer • Trade Name • UNS Number  
**Other Links:** Advertising • Submit Data • Database Licensing • Web Design & Hosting • Trade Publications  
Supplier List • Unit Converter • Reference • News • Links • Help • Contact Us • Site Map • FAQ • Home

Please read our License Agreement regarding materials data and our Privacy Policy. Questions or comments about MatWeb? Please contact us at [webmaster@matweb.com](mailto:webmaster@matweb.com). We appreciate your input.

Site designed and maintained by Automation Creations, Inc. The contents of this web site, the MatWeb logo, and "MatWeb" are Copyright 1996-2006 by Automation Creations, Inc. MatWeb is intended for personal, non-commercial use. The contents, results, and technical data from this site may not be reproduced either electronically, photographically or substantively without permission from Automation Creations, Inc.

BEST AVAILABLE COPY



Data sheets for over 55,000 metals, plastics, ceramics, and composites.

Advertise with MatWeb!



HOME • SEARCH • TOOLS • SUPPLIERS • FOLDERS • ABOUT US • FAQ • LOGIN

Searches: Advanced | Material Type | Property | Composition | Trade Name | Manufacturer



Upload your 3D CAD model, select process, quantity, material, and instantly receive your unique, binding quote.

## 15-Day QuickTurn Injection Mold Tooling Quickparts

### DuPont Hytrel® HTR8206 Polyester Elastomer

[Printer friendly version](#)[Download to Excel \(requires Excel and Windows\)](#)[Export data to your CAD/FEA program](#)[Return to last search](#)Add to Folder: ☐

BEST AVAILABLE COPY

**Subcategory:** Elastomer, TPE; Polyester, TP; Polymer; Thermoplastic**Close Analogs:** Data provided by the manufacturer.**Material Notes:**

Very high moisture vapor transmission rate for breathable film applications.

**Physical Properties**

	Metric	English	Comments
Density	1.19 g/cc	0.043 lb/in <sup>3</sup>	ASTM D792
Melt Flow	12 g/10 min	12 g/10 min	230°C/2.16 kg

**Mechanical Properties**

Hardness, Shore D	45	45	ASTM D676
Tensile Strength, Ultimate	19.2 MPa	2780 psi	ASTM D638
Tensile Strength, Yield	5.1 MPa	740 psi	ASTM D638

Elongation at Break	510 %	510 %	ASTM D638
Flexural Modulus	0.08 GPa	11.6 ksi	ASTM D790
Izod Impact, Notched	NB	NB	ASTM D256
Izod Impact, Notched Low Temp	1.8 J/cm	3.37 ft-lb/in	at -40°C; ASTM D256 Method A
Tear Strength	86 kN/m	491 pli	Initial Tear Resistance, ASTM D1004
Taber Abrasion, mg/1000 Cycles	0	0	CS-17 Wheel, 1000g; ASTM D1044 (modified)

### Thermal Properties

Melting Point	200 °C	392 °F	ASTM D3418
Maximum Service Temperature, Air	38 °C	100 °F	Deflection temperature at 1.8 MPa
Deflection Temperature at 0.46 MPa (66 psi)	62 °C	144 °F	ASTM D648
Deflection Temperature at 1.8 MPa (264 psi)	38 °C	100 °F	ASTM D648
Vicat Softening Point	151 °C	304 °F	Rate B; ASTM D1525

### Processing Properties

Processing Temperature	165 - 260 °C	329 - 500 °F
------------------------	--------------	--------------

Some of the values displayed above may have been converted from their original units and/or rounded in order to display the information in a consistent format. Users requiring more precise data for scientific or engineering calculations can click on the property value to see the original value as well as raw conversions to equivalent units. We advise that you only use the original value or one of its raw conversions in your calculations to minimize rounding error. We also ask that you refer to MatWeb's disclaimer and terms of use regarding this information. [Click here](#) to view all the property values for this datasheet as they were originally entered into MatWeb.



Upload your 3D CAD model, select process, quantity, material, and instantly receive your unique, binding quote.

### Subscribe to Premium Services

**Searches:** Advanced • Composition • Property • Material Type • Manufacturer • Trade Name • UNS Number  
**Other Links:** Advertising • Submit Data • Database Licensing • Web Design & Hosting • Trade Publications  
 Supplier List • Unit Converter • Reference • News • Links • Help • Contact Us • Site Map • FAQ • Home

Please read our License Agreement regarding materials data and our Privacy Policy. Questions or comments about MatWeb? Please contact us at [webmaster@matweb.com](mailto:webmaster@matweb.com). We appreciate your input.

Site designed and maintained by Automation Creations, Inc. The contents of this web site, the MatWeb logo, and "MatWeb" are Copyright 1996-2006 by Automation Creations, Inc. MatWeb is intended for personal, non-commercial use. The contents, results, and technical data from this site may not be reproduced either electronically, photographically or substantively without permission from Automation Creations, Inc.



Data sheets for over 55,000 metals, plastics, ceramics, and composites.

MATERIAL PROPERTY DATA

Searches: Advanced | Material Type | Property | Composition | Trade Name | Manufacturer

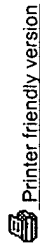
[Advertise with MatWeb!](#)

[HOME](#) • [SEARCH](#) • [TOOLS](#) • [SUPPLIERS](#) • [FOLDERS](#) • [ABOUT US](#) • [FAQ](#) • [LOGIN](#)


Upload your 3D CAD  
model, select process,  
quantity, material, and  
instantly receive your  
unique, binding quote.

## 15-Day QuickTurn Injection Mold Tooling Quickparts

### DuPont Hytrel® HTR8171 Polyester Elastomer


[Printer friendly version](#)

[Download to Excel \(requires Excel and Windows\)](#)

[Export data to your CAD/FEA program](#)

[Return to last search](#)
Add to Folder: ☐

**Subcategory:** Elastomer, TPE; Polyester, TP; Polymer; Thermoplastic

**Close Analogs:** Data provided by the manufacturer.

**Material Notes:**

Very high moisture vapor transmission rate for breathable film applications.

**Physical Properties**

	Metric	English	Comments
Density	1.17 g/cc	0.0423 lb/in <sup>3</sup>	ASTM D792
Melt Flow	9 g/10 min	9 g/10 min	190°C/2.16 kg

**Mechanical Properties**

Hardness, Shore D	32	32	ASTM D676
Tensile Strength, Ultimate	10.2 MPa	1480 psi	ASTM D638
Tensile Strength, Yield	2.8 MPa	406 psi	ASTM D638

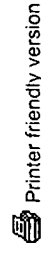
Elongation at Break	<u>210 %</u>	210 %	ASTM D638
Flexural Modulus	<u>0.0248 GPa</u>	3.6 ksi	ASTM D790
Izod Impact, Notched	NB	NB	ASTM D256
Izod Impact, Notched Low Temp	NB	NB	at -40°C; ASTM D256 Method A
Tear Strength	<u>45 kN/m</u>	257 pli	Initial Tear Resistance, ASTM D1004
Taber Abrasion, mg/1000 Cycles	85	85	CS-17 Wheel, 1000g; ASTM D1044 (modified)

### Thermal Properties

Melting Point	<u>150 °C</u>	302 °F	ASTM D3418
Maximum Service Temperature, Air	<u>42 °C</u>	108 °F	Deflection temperature at 0.46 MPa
Deflection Temperature at 0.46 MPa (66 psi)	<u>42 °C</u>	108 °F	ASTM D648
Vicat Softening Point	<u>76 °C</u>	169 °F	Rate B; ASTM D1525

### Processing Properties

Processing Temperature	165 - 260 °C	329 - 500 °F
------------------------	--------------	--------------



[Printer friendly version](#)

Some of the values displayed above may have been converted from their original units and/or rounded in order to display the information in a consistent format. Users requiring more precise data for scientific or engineering calculations can click on the property value to see the original value as well as raw conversions to equivalent units. We advise that you only use the original value or one of its raw conversions in your calculations to minimize rounding error. We also ask that you refer to MatWeb's disclaimer and terms of use regarding this information. [Click here](#) to view all the property values for this datasheet as they were originally entered into MatWeb.

**15-Day QuickTurn**  
Injection Mold Tooling

[Upload your 3D CAD model, select process, quantity, material, and instantly receive your unique, binding quote.](#)

### Subscribe to Premium Services

**Searches:** Advanced • Composition • Property • Material Type • Manufacturer • Trade Name • UNS Number  
**Other Links:** Advertising • Submit Data • Database Licensing • Web Design & Hosting • Trade Publications  
 Supplier List • Unit Converter • Reference • News • Links • Help • Contact Us • Site Map • FAQ • Home

Please read our License Agreement regarding materials data and our Privacy Policy. Questions or comments about MatWeb? Please contact us at [webmaster@matweb.com](mailto:webmaster@matweb.com). We appreciate your input.

Site designed and maintained by Automation Creations, Inc. The contents of this web site, the MatWeb logo, and "MatWeb" are Copyright 1996-2006 by Automation Creations, Inc. MatWeb is intended for personal, non-commercial use. The contents, results, and technical data from this site may not be reproduced either electronically, photographically or substantively without

permission from Automation Creations, Inc.



Data sheets for over 55,000 metals, plastics, ceramics, and composites.

**Advertise with MatWeb!**

**REGISTER NOW**

HOME • SEARCH • TOOLS • SUPPLIERS • FOLDERS • ABOUT US • FAQ • LOGIN

**Searches:** Advanced | Material Type | Property | Composition | Trade Name | Manufacturer

**SEARCH**



Upload your 3D CAD model, select process, quantity, material, and instantly receive your unique, binding quote.

**Quickparts**

## DuPont Hytrel® G4778 Polyester Elastomer

- [Printer friendly version](#)
- [Download to Excel \(requires Excel and Windows\)](#)
- [Export data to your CAD/FEA program](#)

[Return to last search](#)

Add to Folder: ☐

**Subcategory:** Elastomer, TPE; Polyester, TP; Polymer; Thermoplastic

**Close Analogs:** Data provided by the manufacturer.

### Material Notes:

Good balance of low and high temperature properties.

### Physical Properties

	Metric	English	Comments
Density	1.2 g/cc	0.0434 lb/in³	ASTM D792
Water Absorption	2.3 %	2.3 %	24 hr. ASTM D570
Melt Flow	13 g/10 min	13 g/10 min	230°C/2.16 kg

### Mechanical Properties

Hardness, Shore D	47	47	ASTM D676
Tensile Strength, Ultimate	20.7 MPa	3000 psi	ASTM D638



Tensile Strength, Yield	<u>7 MPa</u>	1020 psi	ASTM D638
Elongation at Break	<u>300 %</u>	300 %	ASTM D638
Flexural Modulus	<u>0.117 GPa</u>	17 ksi	ASTM D790
Izod Impact, Notched	NB	NB	ASTM D256
Izod Impact, Notched Low Temp	<u>1.65 J/cm</u>	3.09 ft-lb/in	at -40°C; ASTM D256 Method A
Tear Strength	<u>91 kN/m</u>	519 pli	Initial Tear Resistance, ASTM D1004
Taber Abrasion, mg/1000 Cycles	12	12	CS-17 Wheel, 1000g; ASTM D1044 (modified)

Thermal Properties

Melting Point	<u>208 °C</u>	406 °F	ASTM D3418
Maximum Service Temperature, Air	<u>46 °C</u>	115 °F	Deflection temperature at 1.8 MPa
Deflection Temperature at 0.46 MPa (66 psi)	<u>80 °C</u>	176 °F	ASTM D648
Deflection Temperature at 1.8 MPa (264 psi)	<u>46 °C</u>	115 °F	ASTM D648
Vicat Softening Point	<u>175 °C</u>	347 °F	Rate B; ASTM D1525

Processing Properties

Processing Temperature	165 - 260 °C	329 - 500 °F
------------------------	--------------	--------------



[Printer friendly version](#)

Some of the values displayed above may have been converted from their original units and/or rounded in order to display the information in a consistent format. Users requiring more precise data for scientific or engineering calculations can click on the property value to see the original value as well as raw conversions to equivalent units. We advise that you only use the original value or one of its raw conversions in your calculations to minimize rounding error. We also ask that you refer to MatWeb's disclaimer and terms of use regarding this information. [Click here](#) to view all the property values for this datasheet as they were originally entered into MatWeb.



15-Day QuickTurn  
Injection Mold Tooling

Upload your 3D CAD model, select process, quantity, material, and instantly receive your unique, binding quote.

Subscribe to Premium Services

**Searches:** Advanced • Composition • Property • Material Type • Manufacturer • Trade Name • UNS Number  
**Other Links:** Advertising • Submit Data • Database Licensing • Web Design & Hosting • Trade Publications  
Supplier List • Unit Converter • Reference • News • Links • Help • Contact Us • Site Map • FAQ • Home

Please read our License Agreement regarding materials data and our Privacy Policy. Questions or comments about MatWeb? Please contact us at [webmaster@matweb.com](mailto:webmaster@matweb.com). We appreciate your input.

Site designed and maintained by Automation Creations, Inc. The contents of this web site, the MatWeb logo, and "MatWeb" are Copyright 1996-2006 by Automation Creations, Inc. MatWeb is intended for personal, non-commercial use. The contents, results, and technical data from this site may not be reproduced either electronically, photographically or substantively without permission from Automation Creations, Inc.